

Date: Monday, 2/11/2008 2:12:25 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 37344	
Estimate Number : 10792	
P.O. Number :	Part Number : D3289041
This Issue : 2/11/2008 S.O. No. :	Drawing Number : D3289 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : D
Previous Run : 36187	Material :
Written By :	Due Date : 2/25/2008 Qty: 4 Um: Each
Checked & Approved By : <u>08 02 11</u>	
Comment : Est Rev:A 04-09-28 New Issue KJ/JLM	
Est Rev:B 07-09-09 As per Rev C JLM Verified By:EC	
Est Rev:C 07-12-06 as per Rev D DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-5-108

Web

29985

SL 8-2-20

(4)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5-108 to as per Dwg D3289

2-Transfer drill web from D3283-3 doublers

3-Drill web using DT 8748 as per Dwg D3289

4-Using uni-bit, open holes as per Dwg D3289

5-Deburr holes and ends

SL 8-2-20

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/02/25

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-2-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: / Monday, 2/11/2008 2:12:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 37344

Part Number: D3289041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/02/03 (4)

6.0

D32833

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

(8)

Pick:

Qty Part Number

Description

Batch

2 D3283-3

Doubler

26793

SL 8-2-75

7.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 85.0000 Each(s)/Unit Total : 340.0000 Each(s)

(P10)

Pick:

Qty Part Number

Description

Batch

85 MS20470AD4-7

Rivet

M 105940

(347)

M 8-2-27

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Apply LPS between doublers and web as per dwg D3289

2- Coat rivets with LPS

3- Rivet doublers as per dwg D3289

) M 8-2-27

(4)

A/R

LPS-3

Batch: M 104929

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/03 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

SL 8-3-3

(4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



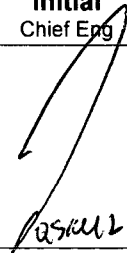
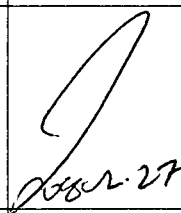
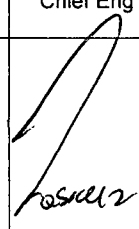
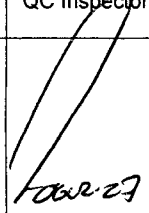
Comment: FINAL INSPECTION/W/O RELEASE

08/03/04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8-2-27	7.0	1 rivet had to be removed and the hole slightly became slightly oversized R.C Human error		Replace rivet Qty 1 with MS 20470 ADS-7 M 2655	H 8-2-27			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Ø0.500
(28 PLACES)

9.000

3.000 PITCH
(TYP)

30.000

3.000 PITCH
(TYP)

Ø0.625
(2 PLACES)

DRILL Ø0.128 HOLES TO
ALIGN WITH D3283-3 DOUBLER
(85 PLACES) C

D3283-3 DOUBLER (2)
MS20470AD4-7 RIVET (85)
INSTALL WITH LPS-3

3.000 PITCH
(TYP)

96.1

84.41

75.63

DETAIL A

D3289-1
WEB

D

40.10

35.08

33.86

32.61

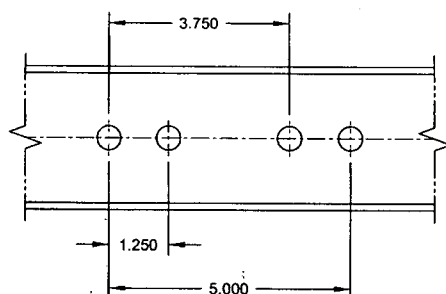
28.63

DETAIL A

22.13

2.67

0.00



DETAIL A
(RIVET HOLES NOT SHOWN)
SCALE 1:5

D3289-041 FLOAT WEB

Qty	Part Number	Description
X	D3289-041	FLOAT WEB
1	D2600-5-108	EXTRUSION
2	D3283-3	DOUBLER
85	MS20470AD4-7	RIVET

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5-108 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-3 DOUBLERS AND D3289-1 WEB. INSTALL RIVETS COATED IN LPS LABORATORIES LPS-3
- 7) WEIGHT: 5.00 lbs

RELEASED
07.11.13

D	MID-FLOAT HOLES ON D3288 WERE MOVED 2.00" FWD & ROTATED INBOARD & OUTBOARD BY 17° DUE TO GHW INTERFERENCE. THEREFORE, 40.10 WAS 38.10.	MB	07.09.14
C	CORRECTED TYPO (-3 WAS -1)	MB	07.06.04
B	ADD HOLES FOR OEM COMPATIBILITY	CP	05.03.16
A	NEW ISSUE	CP	04.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JP</i>	D3289	SHEET 1 OF 1
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	FLOAT WEB, 206A/B	1:10
DATE	07.09.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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